

Sup Monday, Nov 9.

Work Order ID 93515

November-16-12 2:11:42 PM

\*93515\*

Page 1

Item ID: D350-567-111B

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID: PRELIM

Item Name: Floor Window Installation. Extra Large (Blank)

Stop \*NS2\*

Start Date: 16/11/2012 Start Qty: 1.00

\*1\*

Required Date: 19/11/2012 Req'd Qty: 1.00

\*1\*

Reference:

~~PRELIMINARY ISSUE~~  
PRELIMINARY ISSUE  
Customer:



Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9637	A								

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D350-567-111b CHG001

0.00

0.00

DAS  
12/1/14

110

\*110\*

Packaging

Packaging

Pick Kit

Packaging

Memo

0.00

0.00

*[Signature]* 12/1/14 *[Signature]*

120

\*120\*

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

POSITIVE  
RECALL  
DAS  
12/1/14

inspect to  
pkts only

12/1/14

# Work Order ID 93515

November-16-12 2:11:42 PM

**\*93515\***

Page 2

Item ID: D350-567-111B

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: PRELIM

Item Name: Floor Window Installation, Extra Large (Blank)

Stop **\*NS2\***

Start Date: 16/11/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 19/11/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start <b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop <b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-111b								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

**DAS**  
20  
3-8

POSITIVE RECALL

EFFECTIVE 12-11-19 AUTH LC

RELEASED DAS DATE 12/12/14

ECW 12-6-80

is attached

12/12/14 *[Signature]*

ME

12-11-19

# Picklist Print

November-16-12 2:11:42 PM

Page 1

Work Order ID: 93515

Parent Item: D350-567-111B

Parent Item Name: Floor Window Installation, Extra Large (Blank)

Start Date: 16/11/2012

Required Date: 19/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.11.16 NEW ISSUE DD VERE:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-567-113 Replacement Window, Extra Large		Manufactured	No			110	Each	0.0000	1	935/6	2		
D350-567-115B Interior Floor Window, Blank		Manufactured	No			110	Each	0.0000	1	935/4	2		

## 5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
				1	D3293-1	DOUBLER
				1	D3294-1	BRACKET
				1	D3295-041	FLOOR WINDOW
				1	D3296-041	DOOR ASSEMBLY
				1	D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

# **ENGINEERING CHANGE NOTICE** **DART AEROSPACE LTD**

Date:	12.11.20	Job No.:	ENG3100NOV	ADR Yes/No:	Y	ADR Date:	12.11.15	ECN #:	12- 680
Product No.:	D350-567-111B			Created By:	[Signature]		Approved By:	[Signature]	
Product Name:	FLOOR WINDOW INSTALL, EXTRA LARGE (BLANK)			Checked By:	[Signature]				

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	IE	N/A
Production Manager / Coord.	Y	LL/MF	MF 10-11-21
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD	12.12.03
Production Engineering Coord.	N	JLM	
Customer Order Processing	N	RM	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS	5/12/11/21
QC Coordinator	Y	ED	5/12/11/21
Customer Support	Y	SW/LM	12.11.21
Customer Technical Support	Y	MB/DS	12.11.21
Marketing	Y	HM	12.11.21

**Reason for Change:**  
PER PAR12-223, CUSTOMER UPGRADING FROM OEM SMALL WINDOW INSTALL TO DART EXTRA LARGE WINDOW INSTALL: BLANK PARTS REQ'D

**Documents Affected:**  
RELEASE DSI 9637 REV. A, D3293 REV. B, D3294 REV. D, D3295 REV. E, D3296 REV. B

**PAPERWORK UPDATE** ☒ **PARTS MUST COMPLY** ☐ **PREVIOUS PARTS SATISFACTORY** ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	MB/PS	SEE BELOW.	12.11.21
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	MB	MDL-D350-567 REV. J	12.11.21
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.11.21
11	Update Product Specification Files	Y	KJ	DSI 9637 REV. A ON REQUEST ONLY	12.11.21
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.11.21
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ	SEE BELOW.	12.11.21
17	Update / Verify ARC Database	Y	KJ	#4	12.11.21
18	Create / Update Change Record Form / Item Card Database	Y	KJ	D350-567-111B/-115B @ CHG 001	12.11.21
19	Create / Update PPP's	Y	KJ	D350-567-111B/-115B	12.11.21
20	Red Decals required?	Y	KJ	D350-567-111B/-115B	12.11.21
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		12.11.21
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.11.21
24					

**Description / Action:**

- PROVIDE MBH TECHNICS WITH DSI 9637 AND ARC
- ENSURE ALL NEW PARTS ARE IN SYSTEM: B350-567-111B/-115B, D3293-1B, D3294-1B/-3B/-3BF/D3295-041B/-1B, D3296-041B

ECN Verified & Complete: [Signature] Date: 12/12/21

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1  
REF. TCCA STC: SH92-18  
REF. FAA STC: SH989NE AND SH990NE  
REF. EASA STC: EASA.IM.R.S.01560 AND EASA.IM.R.S.01561

## 1.0 PURPOSE

This service instruction is intended for customers wishing to upgrade their existing OEM small vertical reference window kit to a DART D350-567-111 Floor Window Kit. Since the DART D350-567-115 Floor Window Kit included with D350-567-111 does not share the same rivet patterns as the OEM kit, the D350-567-111B/-115B Kits from this service instruction replaces the D350-567-111/-115 Kits to facilitate installation without having to perform extensive rework/repair of the aircraft floor prior to installation.

## 2.0 INSTALLATION OF D350-567-111B:

**Note:** With reference to Installation Instructions D350-567, make the following substitutions:

- D3293-1B replaces D3293-1;
- D3294-1B replaces D3294-1;
- D3295-041B replaces D3295-041;
- D3296-041B replaces D3296-041.






- 2.1 Perform Step 3.3.1 of Installation Instructions D350-567 as required.
- 2.2 Locate the D3293-1B per Figure 1 of this service instruction.
- 2.3 Enlarge the viewing hole in the aircraft floor by using D3293-1B as template.
- 2.4 Transfer drill  $\varnothing 0.128$ " holes from the aircraft floor to D3293-1B Doubler, D3294-1B Bracket, and D3295-041B Window. Drill additional holes as required through D3293-1B and aircraft floor. Ensure minimum pitch and edge distance as indicated.
- 2.5 Enlarge existing  $\varnothing 0.128$ " holes to  $\varnothing 0.141$ " as required and drill qty(4)  $\varnothing 0.141$ " as shown in Figure 1 of this service instruction for a total of qty(9)  $\varnothing 0.141$ " holes.
- 2.6 Locate D3296-041B and transfer drill qty(12)  $\varnothing 0.128$ " and qty(3)  $\varnothing 0.141$ " holes from the D3293-1B Doubler/aircraft floor to the blank hinge blade of D3296-041B.
- 2.7 Complete installation in accordance with Section 3.3 of Installation Instructions D350-567.
- 2.8 Touch up finish on drilled parts in accordance with Section 5.1.3 of ICA-D350-567.
- 2.9 Install the D350-567-113 Kit per Section 3.7 of D350-567. No changes.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 12.11.16  
CERT. NO.: SH92-18  
ISSUE NO.: 6

A	NEW ISSUE	MB	12.11.15
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### 3.0 PARTS LIST

QTY -111B	QTY -113	QTY -115B	Part Number	Description
X			D350-567-111B	FLOOR WINDOW INSTALLATION, EXTRA LARGE (BLANK)
1	X		D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
1		X	D350-567-115B	INTERIOR FLOOR WINDOW KIT (BLANK)
	1		D2463-0860	NEOPRENE SEAL
	1		D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
	12		2600-6	1/4 TURN FASTENER
	12		2600-LW	WASHER
	12		212-12	RECEPTACLE
	21		AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	42		AN960JD8	WASHER
	21		MS21042L08	NUT (OR MS21042-08)
	24		MS20426AD3-5	RIVET
	2 SQ. YD		N/A	9.7 OZ 7781 'S' GLASS UNIVERESAL WEAVE
		1	D3293-1B	DOUBLER, BLANK
		1	D3294-1B	BRACKET, BLANK
		1	D3295-041B	FLOOR WINDOW, BLANK
		1	D3296-041B	DOOR ASSEMBLY, W/BLANK HINGE BLADE
		1	D2463-0530	NEOPRENE SEAL
		9	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
		9	AN960JD6	WASHER
		9	MS21042L06	NUT (OR MS21042-06)
		2	MS20470AD4-5	RIVET
		115	MS20470AD4-6	RIVET
		15	MS20470AD4-7	RIVET

### 4.0 WEIGHT AND BALANCE

For D350-567-111B, use the weight and balance information for D350-567-111..

### 5.0 MAINTENANCE AND CONTINUED AIRWORTHINESS

Maintenance and continued airworthiness instructions for D350-567-111B is the same as for D350-567-111. Refer to ICA-D350-567.

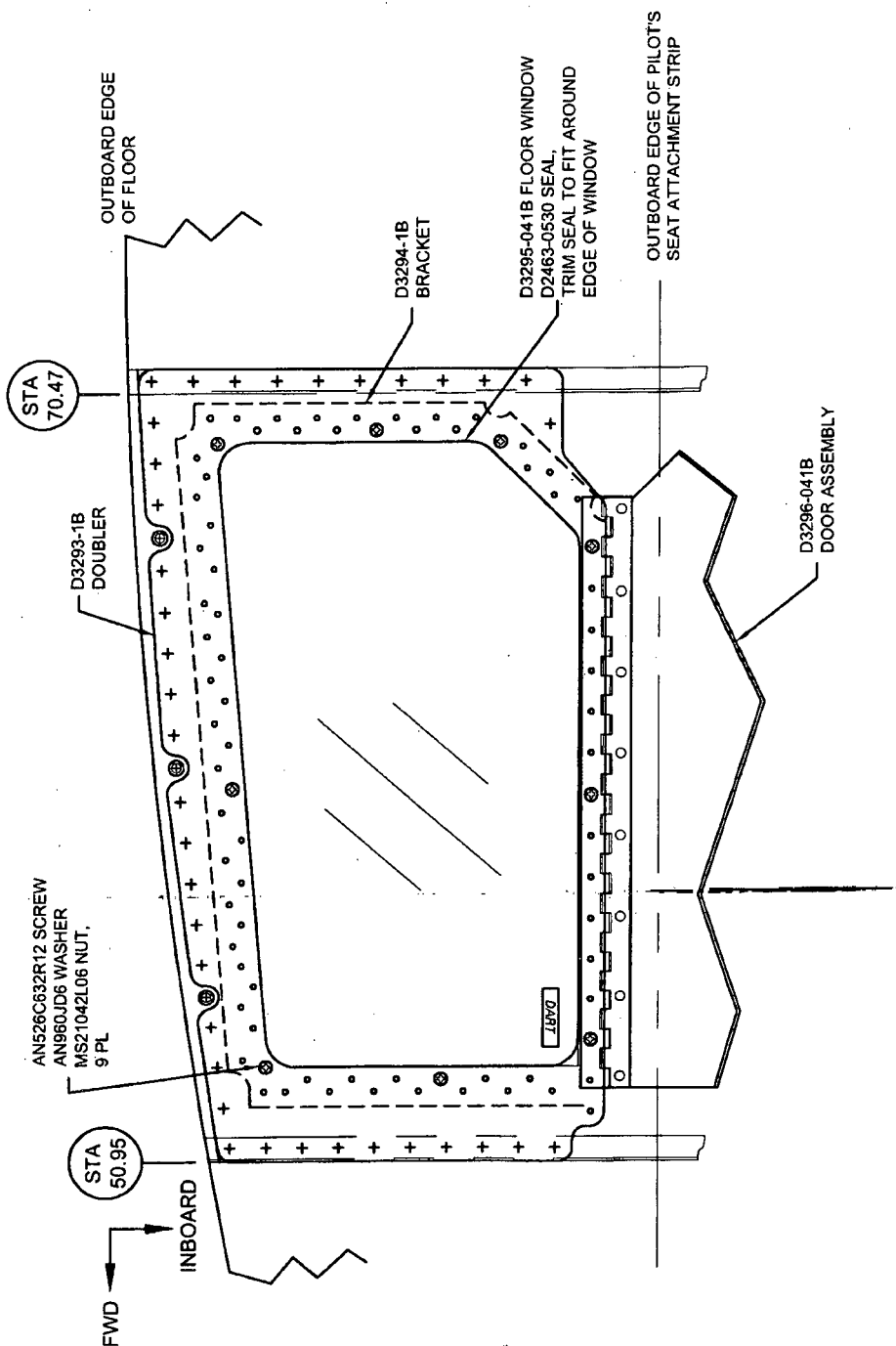
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**FIGURE 1: D350-567-115B KIT OVERVIEW**  
(SLIDING DOOR MOD NOT SHOWN)

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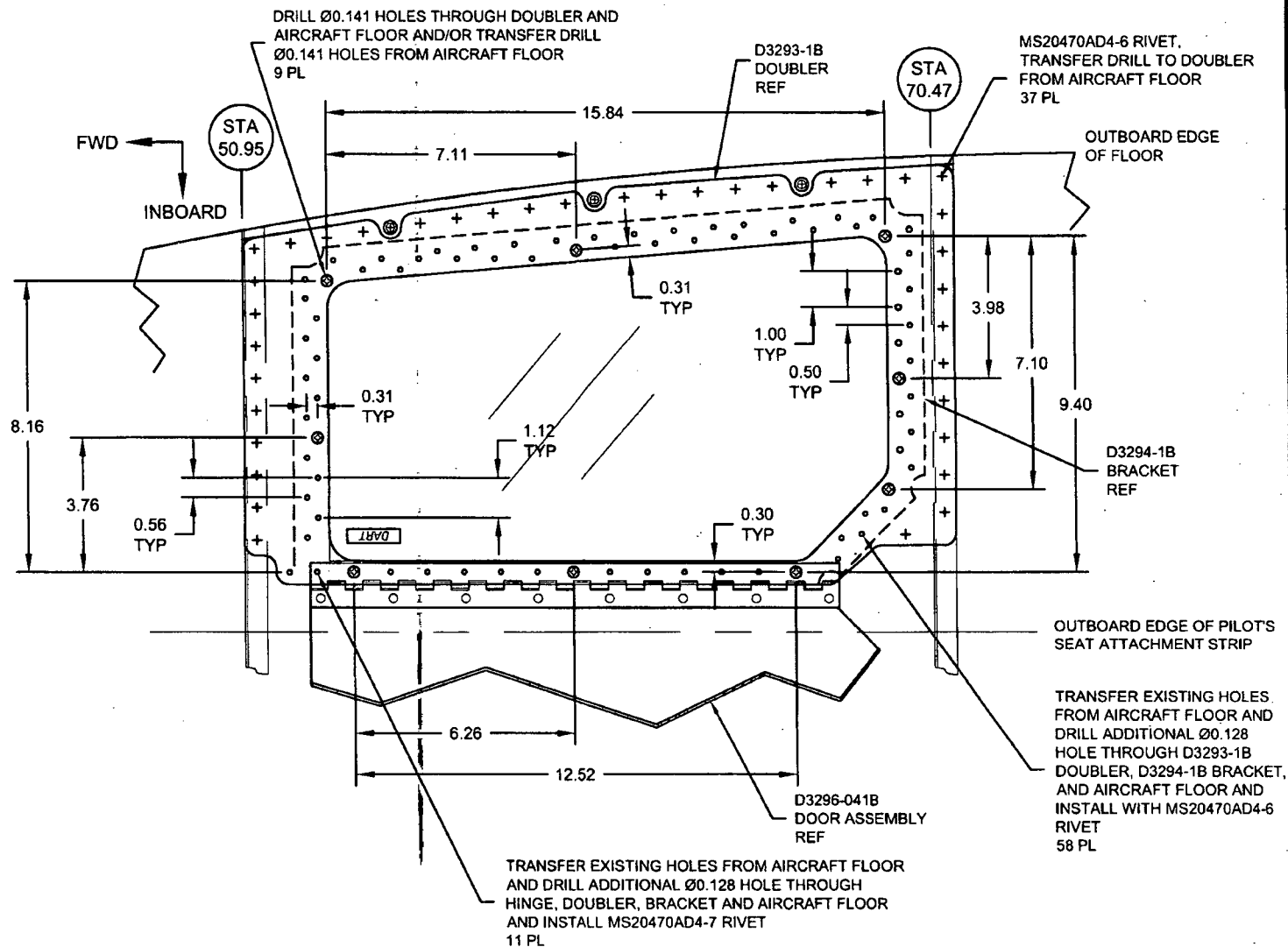
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**FIGURE 2: TYPICAL PITCHES FOR  
ADDITIONAL REQUIRED RIVETS**  
(SLIDING DOOR MOD NOT SHOWN)

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